

Work Order ID 83674

April-23-12 11:12:52 AM

83674

Ship May 4th Page 1

Item ID: D4030-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Long Basket Assembly (350)

Stop

NS2

Start Date: 23/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: *MLJ*

Date: *12/04/23*

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4030	C

100	Pick Kit	0.00
-----	----------	------

100

Packaging

Memo

0.00

Packaging

1x

SP 12-05-03

110	Assemble as per dwg	0.00
-----	---------------------	------

110

HandFinish

Memo

0.00

Hand Finishing

****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****

1x

SP 12/05/04

120	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

120

QC

Memo

0.00

Quality Control

S77654

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83674

83674

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April-23-12 11:12:52 AM

Item ID: D4030-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Long Basket Assembly (350)

Stop

NS2

Start Date: 23/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: *phg*

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCW 12/05/04

MR 2-05-04

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 83674

83674

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-200 *D4086-200* Placard, Max Load		Manufactured	No				Each	17.0000	**	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST122		17							
				72051		1							
				82827		16							
D2530 *D2530* Handle Weldment		Manufactured	No			100	Each	3.0000	**	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST506		3							
				77030		1							
				82150		2							
D2535 *D2535* Spring		Manufactured	No			100	Each	10.0000	**	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		10							
				77488		10							
D2537 *D2537* Bushing		Manufactured	No			100	Each	0.0000	**	2			

SP

B82895 1x SP

B83545 SP

B82896 SP
12-05-03

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

Work Order ID: 83674

83674

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3913-041 Manufactured No

100 Each 0.0000 1 1

D3913-041

Long Basket Base Assembly, 350

D3914-041 Manufactured No

100 Each 0.0000 1 1

D3914-041

Long Basket Lid Assembly (350)

D3917-3 Manufactured No

100 Each 43.0000 6 6

**D3917-3*

Washer

B83676 (1X) **

EP 12/05/04

B83678 (1X) **

EP 12/05/04

** 8P B82936 SA

Location

Loc Qty

Loc Code

ST070

43

76956

4

80598

1

81205

38

D3953-3 Manufactured No

100 Each 52.0000 2 2

D3953-3

Gas Spring Stud, Lid

**

SP

Location

Loc Qty

Loc Code

ST075

52

82044

12

82939

40

D3953-7 Manufactured No

100 Each 62.0000 2 2

D3953-7

Spring Spacer

**

SP 12-05-03

Location

Loc Qty

Loc Code

ST075

62

82045

22

82940

40

2X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 83674

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-9 Manufactured No

100 Each 74.0000 2 2

D3953-9

Gas Spring Washer

**

Sp

Location

Loc Qty

Loc Code

ST075

74

82035

34

82941

40

2x

D3953-17 Manufactured No

100 Each 54.0000 2 2

D3953-17

Gas Spring Spacer

**

Sp

Location

Loc Qty

Loc Code

ST075

54

81206

13

82937

41

1x

D3953-19 Manufactured No

100 Each 53.0000 1 1

D3953-19

Gas Spring Bracket

**

Sp

Location

Loc Qty

Loc Code

ST075

53

75227

1

82938

52

1x

D3953-21 Manufactured No

100 Each 18.0000 1 1

D3953-21

Gas Spring Bracket

**

Sp 12-05-03.

Location

Loc Qty

Loc Code

ST075

18

81207

12

81456

6

1x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 83674

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

83674

D4030-041

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3969-3 Manufactured No

100 Each 61.0000 1 1

D3969-3

Spring (Basket Lid)

**

SP

Location

Loc Qty

Loc Code

ST272

61

64285

1

73515

5

81887

15

82942

40

1x

AN3-14A Purchased No

100 Each 99.0000 4 4

AN3-14A

Bolt

**

SP

Location

Loc Qty

Loc Code

ST352

99

119328

44

121415

30

121444

25

4x

AN3-16A Purchased No

100 Each 101.0000 2 2

AN3-16A

Bolt

**

SP 12-05-03

Location

Loc Qty

Loc Code

ST352

101

117441

47

118628

4

120986

50

2x

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 83674

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

83674

D4030-041

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-17A

Purchased

No

100

Each

110.0000

4

4

AN5-17A

Bolt

**

SP

Location

Loc Qty

Loc Code

338

76

121181

76

ST338

34

117872

34

4x

AN4-12

Purchased

No

100

Each

50.0000

3

3

AN4-12

Bolt

**

SP

Location

Loc Qty

Loc Code

ST357

50

118626

1

119775

25

120986

24

3x

AN310-4

Purchased

No

100

Each

97.0000

3

3

AN310-4

NUT

**

SP 12-05-03

Location

Loc Qty

Loc Code

ST344

97

120124

1

120518

25

121011

1

121162

20

121349

25

121444

25

3x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 83674

83674

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN310C4

Purchased

No

100

Each

83.0000

2

2

AN310C4

Nut

**

SP

Location

Loc Qty

Loc Code

ST344

83

120360

30

121166

28

121444

25

2x

MS21042L3

Purchased

No

100

Each

3,551.000

6

6

MS21042L3

Nut

**

SP

Location

Loc Qty

Loc Code

ST300

3551

117441

16

117885

32

118451

5

118927

3

119017

1411

119075

158

121349

926

1214444

1000

6x

MS21042L5

Purchased

No

100

Each

1,351.000

4

4

MS21042L5

Nut

**

SP 12-05-03

Location

Loc Qty

Loc Code

ST300

1351

116105

5

116548

43

117611

30

119109

1273

4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 83674

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

83674

D4030-041

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS24665-151 Purchased

No

100

Each

263.0000

3

3

MS24665-151

Cotter Pin

**

Sp

Location

Loc Qty

Loc Code

ST309

263

17566

263

3x

MS24665-300 Purchased

No

100

Each

183.0000

2

2

MS24665-300

Cotter Pin

**

Sp

Location

Loc Qty

Loc Code

GA

179

118234

179

2x

ST309

4

116823

4

NAS1149F0432P Purchased

No

100

Each

1,226.0000

6

6

NAS1149F0432P

Washer

**

Sp

Location

Loc Qty

Loc Code

ST275

1226

121255

26

121350

1000

121415

200

6x

NAS1149F0563P Purchased

No

100

Each

1,041.0000

4

4

NAS1149F0563P

Washer

**

Sp 12-05-03

Location

Loc Qty

Loc Code

ST275

1041

117735

41

121350

1000

4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 83674

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

83674

D4030-041

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

568.0000

8

8

NAS1149F0332P

WASHER

**

SP

Location

Loc Qty

Loc Code

ST275

568

117735

25

119225

10

120910

130

120986

200

121259

200

17317

3

Ex

NAS1149C0432R

Purchased

No

100

Each

4,774.000

2

2

NAS1149C0432R

Washer

**

SP 12-05-03

Location

Loc Qty

Loc Code

ST297

1810

117291

810

119124

1000

ST298

2964

121255

2964

2x

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

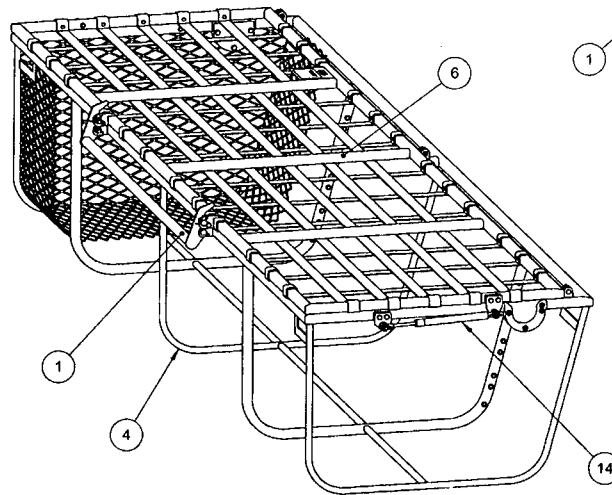
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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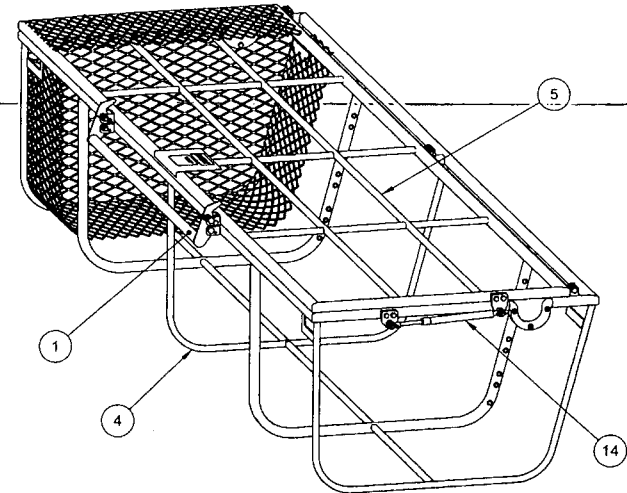
NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	1	D3914-041	LONG BASKET LID ASSY (350)
6	1	1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2	2	AN3-16A	BOLT
17	2	2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20	2	2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83674 MLC
12/04/23



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12.0
ECN 10-596

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (BB-1); QTY FOR ITEM #3 WAS 4 (DB-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A. BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP	DRAWING NO.	REV. C
CHECKED	JP	D4030	SHEET 1 OF 3
MFG. APPR.	JP	TITLE	SCALE
APPROVED	JP	LONG BASKET ASSY (350)	NTS
DE APPR.	JP	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	10.07.23		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

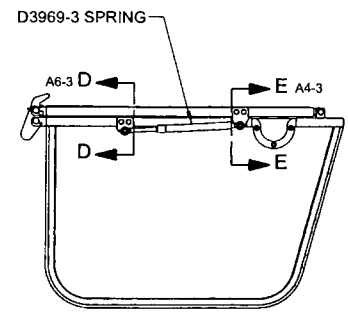
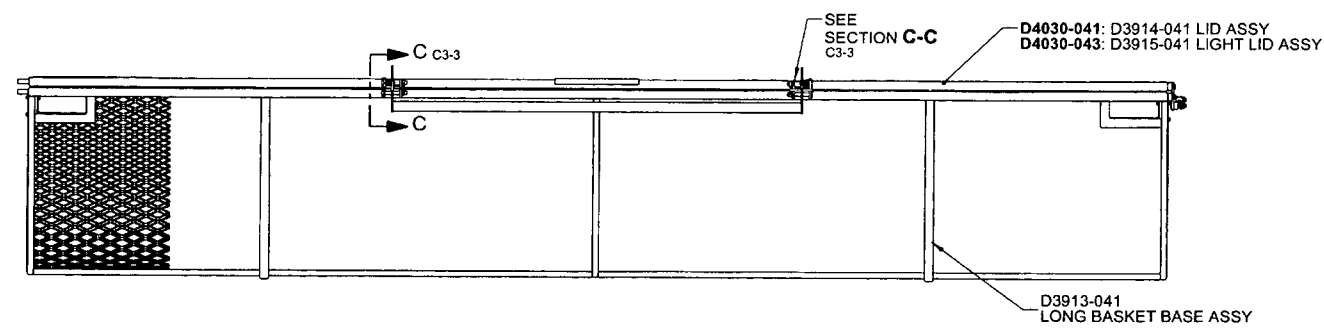
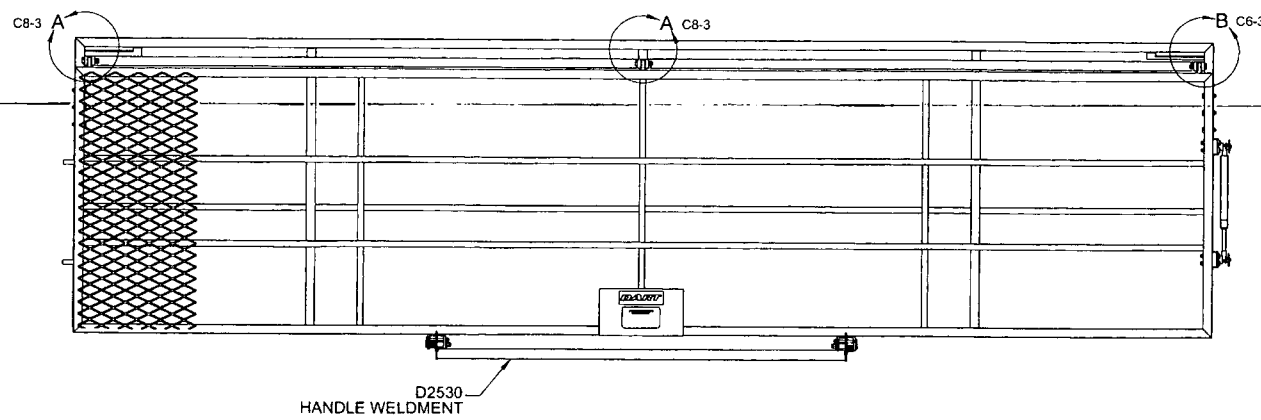
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83674



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12 CP

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SEB	DRAWING NO.	REV. C
MFG. APPR.	SEB	D4030	SHEET 2 OF 3
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	LONG BASKET ASSY (350) _____ NTS.	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

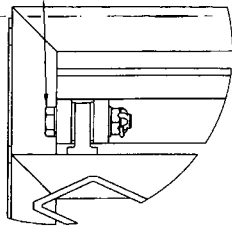
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

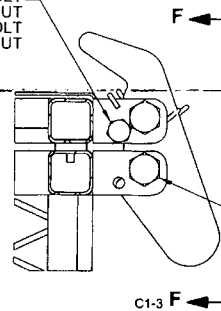
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



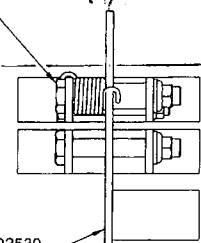
DETAIL A D8-2
D5-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



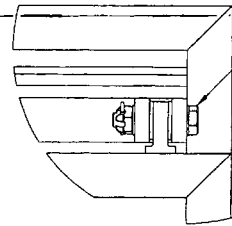
SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D3-2

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT

D2530
HANDLE WELDMENT
REF

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

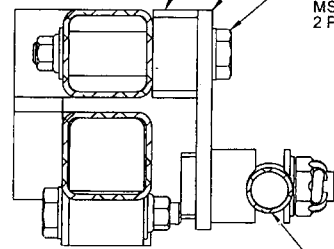
D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL



D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.08.124

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	ALS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4030	SHEET 3 OF 3
APPROVED	JFS	TITLE	SCALE
DE APPR.	JFS	LONG BASKET-ASSY (350)	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries